



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT18510-3
Job Sheet 198884



Part No: RBT18510-3

Job Qty: 4 pcs

Part Name: Stiffener Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18510 Rev.L IPP Rev. A 19.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S215055



Part: RBT18510-3

Job No: 198884

Serial No/Batch: S215055

Revision: L

Inspector:

Exp Date:

Instructions:

Date: 09/19/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	10/3/19		0.00	0.80	Small Fab - 1		GP 19-09-19.
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	4 pcs	10/3/19		0.00	0.00	QC 5 - 10		DAS 40 SEP 20 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
QC 5 - 81									
120	Packaging 3-1 - Stock - B4B	4 pcs	10/3/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	4 pcs	10/3/19		0.00	0.00	QC 21 - SA - 21		SEP 23 2019 DAS 70 9-89
							QC 21 - SA - 70		

Part Op 100 - Assemble as per DWG. See note 7.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location:
 130 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
93286A013	Aluminum Washer 0.265" ID. X 0.688" OD.	GA56 32 Ea (8 ea)	100-Small Fab - 1	5205054
97447A651	Aluminum Blind Rivets 1/4" Dia. X 1/2" Long	GA040 32 Ea (8 ea)	100-Small Fab - 1	5161544
DTSP10002	Handle	GA44 8 pcs (2 ea)	100-Small Fab - 1	5199041
RBT18510-4	Stiffener	GA22 4 pcs (1 ea)	100-Small Fab - 1	5181480

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	93286A013	32	168	0
	97447A651	32	117	0
	DTSP10002	8	48	0
	RBT18510-4	4	6	0
Part Specifications				
Specifications could not be found.				

Plex 8/7/19 9:18 AM Dart.lajeunesse.marie

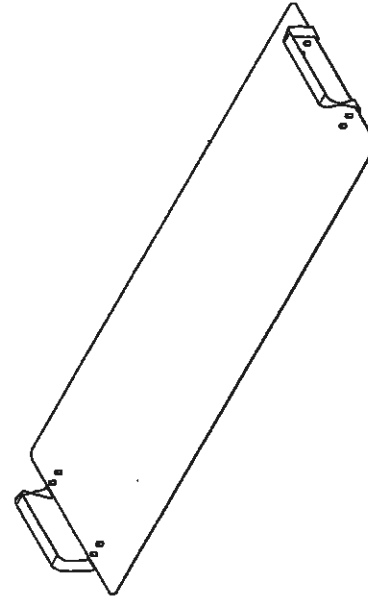
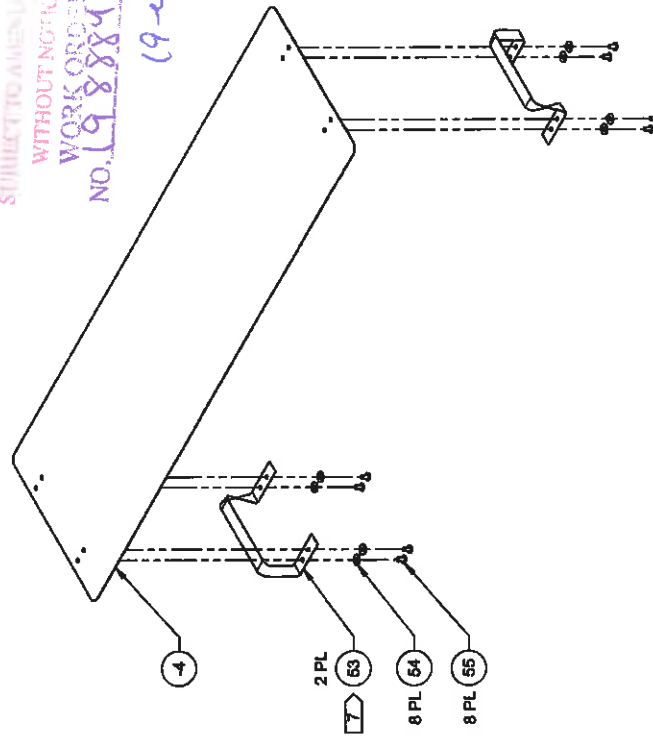
ITEM #	QTY	PART #	PART TITLE
4	1	RBT18510-4	STIFFENER
53	2	DTSP10002	HANDLE
54	8	McMaster#93266A013 OR EQUIV.	ALUMINUM WASHER 0.285" ID. X 0.688" OD. X 0.030"-0.065" THK.
55	8	McMaster#97447A651 OR EQUIV.	ALUMINUM BLIND RIVETS 1/4" DIA. X 1/2" LG.

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 198884 MLS
19-08-07



RBT18510-3 STIFFENER ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1"$
XX = $\pm 0.01"$ / $\pm 0.5"$
XXX = $\pm 0.005"$ / $\pm 0.1"$
XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) INSTALL ITEM 55 TO ITEM 4 USING ITEM 55

DESIGN DRAWN	KPT	DART AEROSPACE LTD HAYNESBURY, ONTARIO, CANADA	REV. L
CHECKED	KPT	TOOL PART # RBT18510	SHEET 8 OF 11
MFG. APPR.	MBS	TITLE JET RANGER FIELD KIT	SCALE NTS
APPROVED	DP	DATE 3/7/2019	NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																																																																								
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)																																																																								
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Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>				Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table>			Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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